Work Orde January-24-14					*11	1887*	*. · · · · · · · · · · · · · · · · · · ·					Page 1
Item ID: Revision ID:	D3391-023	}			Accept	*N900	<b>1040</b>	100	)* s	etup Start	*N	S1*
Item Name:	Mid Tube A	ssembly			-	/				Stop	*N.	S2*
Start Date: Required Date: Reference;	1/24/14 2/07/14	Start Qt Req'd Q		*1 *1	_	Cust Item Customer						
Approvals:	Process P	lan:	<u>_</u> ブ	Date: 17-0	-74 Tooling:	I	Date:		. R	Run Start Stop	*N	R1*
	QC:			_ Date:	<b>SPC</b> (Y/N):	I	)ate:			ж	*N	R2*
Sequence ID/ Work Center II	; <b>D</b>	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty		Reject Number	Insp. Stamp
Draw Nbr	Re	evision Nbr			•							
D3391	I											
*100 *100*	4,	Skidtubes			0.00				<b>D</b>	c_14/	)  29	· · · · · · · · · · · · · · · · · · ·
Skidtubes Skidtubes		. *	Memo	to finish length as pe	0.00 ·							
			2-Drill pilot saddle hole 3-Open sad "J" 4-Remove : 5-Remove ii 6-Deburr 7-Drill #30 paint marke ***DO NO 8-Open wei (10 holes) a 9-Open wei	tholes using DT879 on one side only as of one side only as of oldes and GHW holes of D30" from Fwd inde ndexing ridge on Fwd pilot holes using wellow the pilot holes using wellow arplate holes of D339 as per Dwg D3391 arplate holes of D3391 arplate holes of D339	6 (Do not drill "B" holes) and o	Dwg D3391  0.250" holes with  JIG  G-G to Ø0.250"			)		···	
			(20 holes) a	is per Dwg D3391	WD WEARPLATE HOLES**							

DQA:			Date:											
				-		WORK ORDER NON-CONFORMANCE / UPDATE								
QA Closed:			Date:								Wo	rk Order up	odate only	
Work Orde	er:					DISPOSITION				AGAINST	DEF	PARTMENT	/PROCESS	
Part N	- No				<u> </u>	Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstube Water Jet Machining Small Fab Prod. Eng. Coor. Thermoforming Finishing Rec/Store/Packaging Supplier Supplier Sign &				Engineering Quality Other	
Root		•			Desc	ription of work order update		Initial	A	ction		Sign &	ner.	
Cause		Date	Step	Qty		or non-conformance	Cr	nief Eng	Des	cription		Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved							FΔ	UIT CA	TEGORY					
Landir	ng G	ear /	<u> </u>	•		General	- FA	OLI CA	ILGONI					·
Landi		ear Bending Centre No Cracks Crimp/Kir Cuffs Crushing Heat Trea Inspection Marks/Ch Turning S	nk/Ripple at n Strip in natter	/Wave		Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misreaa Off-set	ion Incomplete/licons Incomplete gned/off center eled	/Unclear	Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	
, ,	-	M/ave/Tw	-		<u> </u>	Fit/Function		Out of Sequence						

Work Order ID 1118	87
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\*111887\*

Page 2

January-24-14 11:14:08 AM

Item ID:

D3391-023

Accept

\*N900040100\*

Setup Start

Stop

**Revision ID:** 

**Item Name:** Mid Tube Assembly

Required Date: 2/07/14

**Start Date:** 1/24/14

**Start Qty:** 1.00

Req'd Qty: 1.00

\*1\*

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

QC:

Date:

Process Plan: Date: Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Sequence ID/ Work Center ID Operation **Description**  Set Up/ **Run Hours** 

Tool ID

De 14/01/28

Tool # Plan Code Accept Qty

Reject Qty

Reject Number

Insp. Stamp

11-Locate D3391-021 in D3391-023 at 9.00" (see view z-z)

10-Open .375" holes to .438" \*\*\*do not open fwd saddle holes\*\*\*

12- Transfer drill one fwd saddle hole only to .188" dia, transfer drill all remaining fwd saddle holes using DT 8149 locating from previusly drill .188" dia hole, using t-pins and clicos to ensure perfect allingment, open up previusly tranfer drilled pilot holes in D3391-023/-021 to 0.438" dia. in D3391-021 D3391-021 BATCH: 101 (040)

- 13- Using DT8217, locating from two previously drilled holes, drill remaining wearplate holes into D3391-021.
- 14- Locating from two fwd wearplate holes in D3391-023 drill remaining 6 wearplte holes in D3391-021 using DT8937
- 15- Open 10 wearplate holes in D3391-021 to 0.297" dia.
- 16- insert D3391-021 into D3391-23
- 17- insert T-pins into first and third fwd saddle holes
- 18- ON FIRST SIDE ONLY drill out 2nd and forth fwd saddles holes to 0.500" as per
- 19- ON 2ND SIDE ONLY ream out 2nd and forth saddle hole to 0.499".
- 20-Deburr and blow out all chips from inside tube, scribe batch # in D3391-023 at aft end.

Training Transport	DQA:		Date:			· · · · · · · · · · · · · · · · · · ·								
Work Order:  Part No.  NCR No.    Disposition   Rework   Scrap   Use-as-is   Suspected Unapproved   Use-as-is   Large Fab   Composite   Co						· · · · · · · · · · · · · · · · · · ·								
Rework   Skid-tube   Crosstube   Water Jet   Engineering   Quality   Quality   Description of work order update   Cause   Date   Step   Qty   Or non-conformance   Cause   C	QA Closed:		Date:							<u>-</u> .	Wo	ork Order up	odate only	
Rework   Scrap   Use-as-is   Suspected Unapproved   Use-as-is	Work Order					DISPOSITION				AGAINST	DE	PARTMENT,	/PROCESS	
Root Cause Date Step Qty Or non-conformance Chief Eng Description Doc/Data Equip/Tooling Handling/Pre Handling/Pre Composite Chief Eng Description Coffset/Setup Composite Chief Eng Chief	Work Oraci	•	-		<del></del>	Rework	<b>I</b> .		Skid-tube	Crosstube			Water Jet	Engineering
Root Cause Date Step Qty Or non-conformance Chief Eng Description Date Verification QC Inspector  Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Design Date Norman Process Supplier	Part No	<b>)</b> .				l ——				,		Pro	d. Eng. Coor.	
Root Cause Date Step Qty Description of work order update Or non-conformance Chief Eng Description Date Verification QC Inspector  Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Equip Transpo						Use-as-is		Therr	noforming	Finishing		Rec/Sto	re/Packaging	Other
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector  Design Doc/Data	NCR No	o				Suspected Unapproved			Large Fab	Composite			Supplier	
Cause Date Step Qty or non-conformance Chief Eng Description Date Verification QC Inspector  Design Doc/Data									· · · · · · · · · · · · · · · · · · ·				· •	
Design	Root				Desc	·	1		ĺ			-		
Doc/Data		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption		Date	Verification	QC Inspector
Equip/Tooling Handling/Pre Hand	<u> </u>	4												
Handling/Pre	<u> </u>	-												
Material	·													
Operator Offset/Setup Process Supplier Training Transport  Offset/Setup	_	-												
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Training Transport														
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FAULT CATEGORY							FA	ULT CA	regory					
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Bending Bend Folio/Program Outside Dimensions Pressure/Forced	<u> </u>		-		_	4		1	rogram			i	<del>-</del>	<b>⊣</b>
Centre Not Concentric BOM/Route Grain Over/Under tolerance Set-up	-	_		ntric	<u> </u>		-	i				1 '		<b>-</b>
Cracks Broken/Damage/Defect Hardware Part Incorrect Temperature/Cure Crimp/Kink/Ripple/Wave Burrs Inspection Incomplete/Unqualified Part Lost/Missing Weld	<u> </u>	_			$\vdash$	<del>-</del>		4		anualifiad		4	<del> </del>	<b>-</b>
	-	<b>-</b>	Kink/Ripple	e/Wave	-	₹	┝	1 .	•			1		
Cuffs	<u> </u>		na		-	4	┝	4		Jiicleal	$\vdash$	4		
Heat Treat Cut Too Short Mislaheled Power Loss/Surge Other	-	_			$\vdash$	4	$\vdash$	1 '	=		$\vdash$	4		Other
Inspection Strip in Tube Drawing Misread	*			Tube	$\vdash$			1				]. 26. 2300/		
Marks/Chatter Drill Holes Off-set	] <u> </u>	<b>⊣</b> `	=			-	_	4					<del></del>	
Turning Sequence Finish Out of Calibration	-	_		<b>!</b>	<b>—</b>			4						
Wave/Twist in Tube Fit/Function Out of Sequence		_						· ·						

Work Order ID 111887

\*111887\*

Page 3

January-24-14 11:14:08 AM Item ID: D3391-023 Accept \*N900040100\* Setup Start **Revision ID:** Stop Mid Tube Assembly Item Name: \*1\* Start Otv: 1.00 Start Date: 1/24/14 Cust Item ID: Required Date: 2/07/14 **Req'd Oty:** 1.00 \*1\* **Customer:** Reference: Run Start Process Plan: Date: Tooling: **Approvals:** Date: Stop Date: SPC (Y/N): OC: Date: Sequence ID/ Set Up/ Tool # Plan Reject Reject Operation Tool ID Accept Insp. Work Center ID Otv Otv Code Number Stamp Description Run Hours 110 QC5- Inspect part completeness to step on W/O 0.00 DAG m 140327 OC 0.00 Memo 9-89 **Quality Control** 120 Chemical Conversion Coat per QSI005 4.1 0.00 \*120\* HandFinish 0.00 Memo Hand Finishing

130

Quality Control

QC7-Inspect Chemical Conversion Coat

0.00

Memo

0.00

1 & 0x14/03/28

DQA:			Date:			– · · · · · · · · · · · · · · · · · · ·									
						WORK ORDER NON-	-CC	ONFO	RMANCE / U					_	AEROSPACE
QA Closed:			Date:								W	ork Order up	date only		
Work Orde	er:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
	•			,	_	Rework			Skid-tube	Crosstube		]	Water Jet	$\Box$	Engineering
Part I	No.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	┪	Quality
	•					Use-as-is			noforming	Finishing		1	re/Packaging	┨	Other
NCR I	No.					Suspected Unapproved			Large Fab	Composite			Supplier		
Root					Desci	ription of work order update	١	nitial	Ac	ction		Sign &		1	,
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	4	QC Inspector
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Handling/Pre															
Material															!
Operator															
Offset/Setup															
Process														Ì	
Supplier	-	'												ļ	
Training	Ш														
Transport	<u> </u>		1											1	
Unapproved			<u> </u>				<u> </u>	III CA	TEGORY						<del></del>
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	┝─┤	Centre No	at Concer	ntric	$\vdash$	BOM/Route		Grain	rogram		<u> </u>	Over/Under		—	Set-up
		Cracks	or concer	itiic	.  -	Broken/Damage/Defect	-	Hardwa	are			Part Incorre		—	Temperature/Cure
		Crimp/Kir	nk/Rinnle	/Wave		Burrs		4	ion Incomplete/U	Inqualified	H	Part Lost/Mi		_	Weld
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		Crushing				Countersink		4	gned/off center			Positioned V			-
•	_	Heat Trea	ıt			Cut Too Short		Mislab			Г	Power Loss/	· · ·	7	Other
	$\vdash$	Inspection		Tube		Drawing	Misread				-				
	一	Marks/Ch	•			Drill Holes		Off-set					_		
		Turning S				Finish		Out of	Calibration						
		Wave/Tw				Fit/Function	Out of Sequence								

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Work Ord January-24-14			·	*111				Page				
Item ID: Revision ID:	D3391-023			Accept	*N900	040	100	)*	Setup S	Start	*N	S1*
Item Name:	Mid Tube A	ssembly							\$	Stop	*N:	S2*
Start Date: Required Date Reference:		Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item 1 Customer:	D:						
Approvals:	Process P	lan:	Date:	Tooling:	D	ate:	_			Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:			S	Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description Skidtubes		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	t Rejec Qty		Reject Number	Insp. Stamp
*140* Skidtubes Skidtubes		Memo 1-Open floa	t bag holes as per dwg at bag holes as per dwg	).000	14-3-2	<u> 8</u>						

150

QC5- Inspect part completeness to step on W/O

3- Prepare tube for welding

4-Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

A/R Sikaflex exp: 4-10-09

batch#: 12 8626

NOTE:ENSURE WEB IS INSERTED IN AFT END OF TUBE

0.00

\*150\* QC

**Quality Control** 

Memo

0.00

Page 4

DQA:			Date:										TOAPT
						<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:			Date:							W	ork Order up	odate only	
Work Orde	or.					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
Work Orac	٠,					Rework			Skid-tube Crosstub	<u>-</u>	1	Water Jet	Engineering
Part N	lo.					Scrap			Machining Small Fa	—	Pro	d. Eng. Coor.	Quality
	•					Use-as-is		i i	moforming Finishin	g	4	re/Packaging	Other
NCR N	۱o.					Suspected Unapproved			Large Fab Composite		]	Supplier	
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Root		Data	Cton	O+1.	Desci	ription of work order update	ı	nitial iief Eng	Action		Sign & Date	Verification	QC Inspector
Cause		Date	Step	Qty		or non-conformance	l Cn	ilei Elig	Description	· ·	Date	verification	QC IIISPECTOI
Design Doc/Data						vi s							
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		Bending			<u> </u>	Bend	<u> </u>	1 '	Program	┡	Outside Dim	. ⊨	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		-	Over/Under		Set-up
		Cracks			-	Broken/Damage/Defect		Hardwa		-	Part Incorre	_	Temperature/Cure
		Crimp/Kir	ık/Ripple	/Wave		Burrs	⊢	4 '	ion Incomplete/Unqualified	$\vdash$	Part Lost/M	· · -	Weld
	_	Cuffs			$\vdash$	Contamination	_	4	tions Incomplete/Unclear	$\vdash$	Part Moved		Wrong Stock Pulled
	<u> </u>	Crushing			-	Countersink	-	1	gned/off center	$\vdash$	Positioned V		Tother.
	$\vdash$	Heat Trea		T l	_	Cut Too Short	$\vdash$	Mislabe		L	Power Loss/	ourge [	Other
	_	Inspection		ıupe	$\vdash$	Drawing Drill Holos	$\vdash$	Misrea					
		Marks/Ch Turning S			-	Drill Holes Finish	$\vdash$	Off-set	Calibration				
		•	•		-	4	<b> </b>	4					
		Wave/Tw	ist in Tub	e e		Fit/Function	1	Out of	Sequence				

Work	Order	ID	111887	
MIUIN	Oluci	w	<b>TTTOO</b> /	

## \*111887\*

Page 5

January-24-14 11:14:08 AM Item ID: D3391-023 Accept \*N900040100\* Setup Start Revision ID: Stop Item Name: Mid Tube Assembly \*1\* **Start Oty: 1.00 Start Date:** 1/24/14 **Cust Item ID:** Required Date: 2/07/14 Rea'd Otv: 1.00 \*1\* **Customer:** Reference: Run Process Plan: Date: Tooling: Approvals: Date: Stop SPC (Y/N): Date: Date: Tool ID Tool # Plan Reject Operation Set Up/ Accept Reject Insp. Sequence ID/ Description Oty Number Stamp Work Center ID Code Oty **Run Hours** 160 0.00 Skidtubes \*160\* Skidtubes 1-Weld crossbolt spacer as per dwg D3391 & QSI 004 P/R M127 763 Skidtubes 2-grind weld flush OC10- Inspect visual per OSI004- ground welds 170 0.00 MON-640 \*1.70\* QC '` 0.00 Memo **Ouality Control** 180 QC5- Inspect part completeness to step on W/O 0.00 \*120\* EO.VOVI OC 0.00 Memo Quality Control

DQA:			Date:				TART						
						<b>WORK ORDER NON-</b>	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:		=	Date:							W	ork Order up	date only	
Work Orde	or.					DISPOSITION			AGAIN	IST DI	PARTMENT	PROCESS	
Work Orak	-				_	Rework	1		Skid-tube Crosstu	ıbe□	7	Water Jet	Engineering
Part N	۷o.					Scrap			Machining Small F		Pro	d. Eng. Coor.	Quality
	•	· · · · · · · · · · · · · · · · · · ·				Use-as-is			noforming Finish		-1	e/Packaging	Other
NCR I	No.					Suspected Unapproved			Large Fab Compos	_ ←	]	Supplier	
Root					Desc	ription of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Description		Date	Verification	QC Inspector
Design	Ш		•										
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Handling/Pre	Щ												
Material	Ш												,
Operator	Ш			<u> </u>									
Offset/Setup	Ш	:					ļ						
Process	Ш												
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	Ш	Bending			-	Bend		- 1	Program	ŀ	Outside Dim	<u> </u>	Pressure/Forced
	Ш	Centre No	ot Concer	ntric	-	BOM/Route	<u> </u>	Grain		-	Over/Under	<u> </u>	Set-up
	-	Cracks	, ,		-	Broken/Damage/Defect	H	Hardwa		F	Part Incorred	<del>} -</del>	Temperature/Cure
	$\vdash$	Crimp/Kir	ik/Ripple	/Wave	-	Burrs	-	<b>⊣</b> `	ion Incomplete/Unqualified	-	Part Lost/Mi	issing	Weld
	-	Cuffs			-	Contamination	$\vdash$	-	tions Incomplete/Unclear	<u> </u>	Part Moved	L. Vrang	Wrong Stock Pulled
	-	Crushing	è		<u> </u>	Countersink	<u> </u>	- '	gned/off center	  -	Positioned V	_	Tothor
	-	Heat Trea		<b>-</b> t	$\vdash$	Cut Too Short	Mislabeled Power Loss/Surge Other			Totilei			
	-	Inspection	-	Tube	$\vdash$	Drawing	$\vdash$	Misrea					· · · · · · · · · · · · · · · · · · ·
	$\vdash$	Marks/Ch			-	Drill Holes	-	Off-set					· · · · · · · · · · · · · · · · · · ·
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	1	Wave/Tw	ist in Tub	oe e	1	Fit/Function	1	Out of	Sequence				

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Work Ord January-24-14				*111	1887*							Page (	6
Item ID: Revision ID:	D3391-023			Accept	*N900	0040	100	)*	Setup	Start Stop		S1*	
Item Name: Start Date: Required Date	Mid Tube Ass 1/24/14 :: 2/07/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item Customer:					Stop	*N:	S2*	
Reference: Approvals:	Process Pla	an:	Date:	Tooling: _ _ SPC (Y/N):		Pate:			Run	Start Stop		R1*	
Sequence ID/ Work Center		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rejo Qty		Reject Number	R2* Insp. Stamp	
*1 Q 5 * HandFinish Hand Finishing		Memo	05 4.3 ODINE AS PER PAR09	0.00				1		H,	442		
190 <b>*10</b> *100  Powdercoat		White Gloss(Ref:4.3.5.1)  Memo	per QS1005 4.3-Alum	0.00				_/		( <u></u> <u> </u>	4-4-x	? <b>8</b> 0	89 48 89
Powder Coating			IPÉRATURE:	<del>22</del>									

0.00

0.00

200

\*20U\*

Quality Control

QC3- Inspect Part Finish

Memo

DQA:			Date:												
·			•			WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:								W	ork Order up	odate only		
Work Orde	٠r٠					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
WOIK OIG	-1.				_	Rework	1		Skid-tube	Crosstube			Water Jet		Engineering
Part N	lo.					Scrap			Machining	Small Fab	-	Pro	d. Eng. Coor.	П	Quality
	•		·			Use-as-is	1		noforming	Finishing	_		re/Packaging	一	Other
NCR N	lo.					Suspected Unapproved	1 1		Large Fab	Composite	_	,	Supplier	一	
_							_						,		
Root					Desci	ription of work order update	Ī	nitial	Ac	tion		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	<u> </u>	QC Inspector
Design	_						l								
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Equip/Tooling	$\Box$						1								
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Material													* .	1	. [
Operator	$\dashv$											-			
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Training							E								•
Transport Unapproved	Н														
опаррточец			L				FAI	ULT CAT	regory						
Landi	ng G					General								-	
		Bending				Bend		Folio/P	rogram			Outside Dim	ensions		Pressure/Forced
		Centre No	t Concer	ntric		BOM/Route		Grain	J			Over/Under	tolerance	$\Box$	Set-up
		Cracks		•		Broken/Damage/Defect		  Hardwa	ire			Part Incorred	ci		Temperature/Cure
		Crimp/Kin	k/Ripple	/Wave		Burrs		Inspect	ion Incomplete/U	nqualified		Part Lost/Mi	issing		Weld
		Cuffs				Contamination		Instruct	ions Incomplete/	Unclear		Part Moved			Wrong Stock Pulled
		Crushing				Countersink		]Misalig	ned/off center			Positioned V			
		Heat Trea	t			Cut Too Short		Mislabe	eled			Power Loss/	Surge	Ш	Other
		Inspection	n Strip in	Tube		Drawing		Misread	t			<u> </u>	,, <u>,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,</u>		
		Marks/Ch	atter			Drill Holes		Off-set							
		Turning S				Finish		4	Calibration			-			
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Page 7

January-24-14	11:14:08 AM												
Revision ID:	D3391-023  Mid Tube Asse	embly		Accept	*N900	<b>040</b>	100	<b>)*</b> s	Setup	Start Stop		S1* S2*	
Start Date: Required Date: Reference:	1/24/14 2/07/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:							
Approvals:		n:	Date:	Tooling: SPC (Y/N):		ate:		R	tun	Start Stop		R1* R2*	
Sequence ID/ Work Center II 230  *270* HandFinish Hand Finishing		Operation Description  HandFinishing  Memo 1- press fit I	D3591-1 spacers using DTS erts as per Dwg	Set Up/ Run Hours 0.00 0.00 9416 starting from 0.500"	Tool ID	Tool#	Plan Code	Accept Qty	Reje Qty	ľ	Reject Number	Insp. Stamp	ر (ح
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	<u> </u>	Cuffs				Contamination	<u> </u>	4	tions Incomplete/	Jnclear	_	Part Moved	<b>L</b> _		Wrong Stock Pulled	
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	Wave/Twist in Tube					Fit/Function		Out of Sequence								

Work Ord January-24-14					Page 8							
Item ID: Revision ID: Item Name:	D3391-023 Mid Tube As			Accept *N900040100* Setup Start Stop								
Start Date: Required Date Reference:	1/24/14 :: 2/07/14	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item ID: Customer:							S2*
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Sequence ID/ Work Center I	ID .	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp

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QC21- Final Inspection - Work Order Release

Memo

Quality Control

14-7-11

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## **Picklist Print**

January-24-14 11:14:13 AM

Work Order ID: 111887

\*111887\*

Parent Item:

D3391-023

\*D3391-023\*

Parent Item Name:

Mid Tube Assembly

**Start Date: 1/24/14** 

Required Date: 2/07/14

Start Otv: 1.00

Required Oty: 1.00

**Comments:** 

IPP A05.10.20New Issue

KJ/EC

IPP B06,02,10ECN773 dwg rev.D

EC

IPP C 07.03.20 rev F dwg EC

IPP D 07.03.28

EC

IPP E 07.10.31 ecn 1053P

EC

IPP Rev:F ECN 1056 07-11-13 DD

verified by: EC

re-format

IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

IPP Rev: I 08-11-13 Removed steps per w/o. OC KJ verified by: ec

Rev. Ladd in sea 140 expire date &h# sikafley DD 10.02.17 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-1-100		Manufactured	No			100	Each	89.0000	1	1	/ /		
*D2500-1	-100*								**	OC 14	loi   28	•	
anne. Life de	*			Location		Loc	<del>_</del>	Loc Code		,	<b>y</b>		
· · · · · · · · · · · · · · · · · · ·					82373 86065		89 28 61		- - -	(I)			• • • •
D3389-1		Manufactured	No			140	Each	3.0000	1	1			
*D3380_1	*								**				

173389-1

Web

Location	L	oc Oty	Loc Code
LG002 (1/3057)		3	•
<del>108</del> 410	160	4.3 Each	212,0000

EC 14-3-28 BE14-03-3/

D3681-1

Manufactured

Loc Qty

\*\*

\*D3681-1\* Spacer

> Location LG001 102202

Loc Code

108647 109109

65 136

212

11

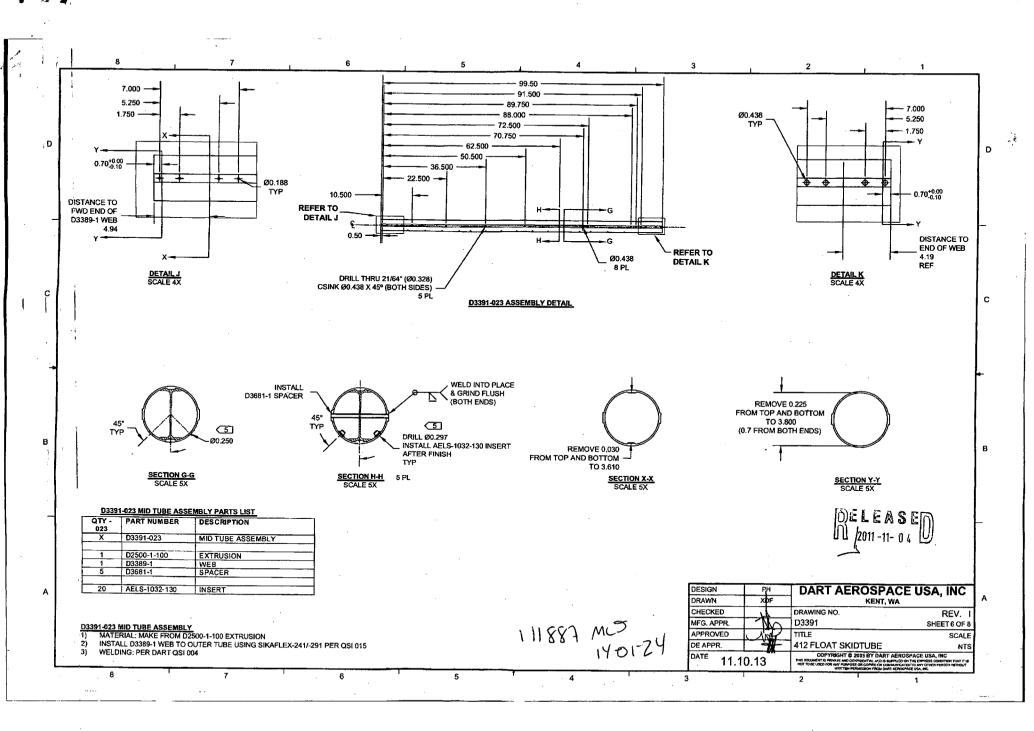
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QA Closed:			Date:								W	ork Order up	date only					
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	-					Rework			Skid-tube	Crosstube			Water Jet	Engineering				
Part N	lo.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	Quality				
	•					Use-as-is		Therr	noforming	Finishing		Rec/Sto	e/Packaging	Other				
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January-24-14 11:14:13 AM

Work Order ID: 111887 \*111887\* D3391-023 \*D3391-023\* Parent Item: Required Date: 2/07/14 Parent Item Name: Mid Tube Assembly **Start Date: 1/24/14** Required Oty: 1.00 Start Oty: 1.00 Manufactured Each 102.0000 2 D3591-1 \*\* \*D3591-1\* Bushing Location Loc Oty Loc Code FG 10 13115645 92873 10 FP001 92 100699 11 107918 40 109107 41 20 ALS4-1032-130 230 Each 1,817.000 20 No Purchased \*AI-S4-1032-130\* 14/04/04 \*\* Rivnut Location Loc Qty Loc Code st510 1817 11128649 X 20 M126109 1817

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]	Wave/Twist in Tube					Fit/Function									